

Date: Wednesday, 29/10/2008 4:23:43 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 43090		
Estimate Number	: 10268		
P.O. Number	:	Part Number	: D350636014
This Issue	: 29/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2750 REV F
First Issue	: //	Project Number	: N/A
Previous Run	: 43089	Drawing Revision	: F
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 20/11/2008
Checked & Approved By	: <u>JLD 08.10.30</u>	Qty:	1 Um: Each
Comment	Est Rev:H 02.09.25 Rearranged procedure steps KJ Est Rev:I 05.12.08 Rearranged procedure steps EC Est Rev:J 06.03.30 Per rev. D EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-09-23 revF as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JLD 08.11.18



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 004

See 11/18

2.0	D26003BENT	Extrusion Bent
-----	------------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2600-3-Bent	Extrusion (Bent)	<u>42940</u>

ET 08-11-09

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: *22242 BE 08/11/05*

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 7 (D2750-4 details). Drill using drill Jig DT8150 & DT8864.

ET 08-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolt using DT8983. Open to 0.500".

5- locate DT8929 off of blade fitting holes and drill pilot holes for blade fitting.

6-Open up holes for section BE-BE to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail A-B to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail A-A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M109213 BE 08/11/05*

10-Grind welds flush as per Dwg D2750

11- scribe batch #.

*8T
08-11-05*

7 JB 8-11-6

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/11/06 (+0)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/06 (+0)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-11-8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-11-10

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

43109

SL 8-11-8

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B-43013

AWM 8-11-10

4PCS X

11.0

D34905

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B-32957

AWM 8-11-10

4PCS X

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

B-41113

AWM 8-11-10

8PCS X

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

109449

exp. date:

8-12-1

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

SL 8-11-8

W/O:		WORK ORDER CHANGES					
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Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

(welding instructions on sheet 11)

A/R

Aluminum Rod

batch:

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch:

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Install inserts as per dwg D2750

✓ 2-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

JL

08-11-14

(X)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 13 42778

JL

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 13 412982

JL

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: 13 42479

JL

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: 13 412927

JL

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 13 43147

JL

08-11-17

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D37943	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 13413116

JW

27.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1342926

JW

28.0	D353625	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342980

JW

29.0	D35371	Wearpad
------	--------	---------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 1342351

JW

30.0	D36311	Washer
------	--------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 1341141

JW

31.0	D3488042	Blade Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: 1342415

JW

32.0	NAS1611010	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

NAS1611-010 batch: (3x) M1106513

(or MS28775-010) batch: (5x) M1101029

JW

08-11-17 *(X)*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1611005

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch:

u/a this one time only ending

34.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1342936

JU

35.0

D3492045

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1342478

JU

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M109545

JU

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M108880

JU

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M109765

JU

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M106896

JU

08.11.17

QU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: (30x) M109752 / (8x) M109798

98

41.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M109632

98

42.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M109754

98

43.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M109740

98

44.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M105728

98

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750

sikaflex batch: M109419 08/11

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: M109539

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M109449

98 08-11-18 98

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

EXP DATE: 08/11

5-assemble o-ring as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: M101223

6-Coat all exposed fasteners with "LPS Procyon" batch: M104251

W 08-11-18 (X)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/18 (X)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B42222

SD

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M109632

SD

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M109840

SD

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109772

8/11/18

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 43090

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

SP

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B40029

8/11/18

(X)

SP

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/11/18 (X)

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

doc 72

Rec G 8/11/18

(X)

SP

56.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/19

Job Completion



MF 08-11-18

B43090

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C4A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

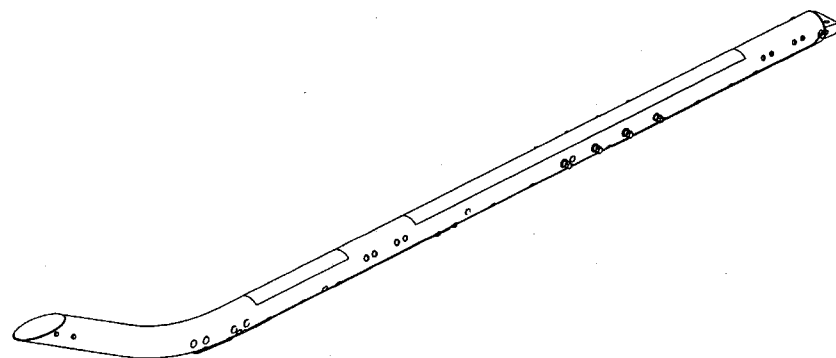
GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER-COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

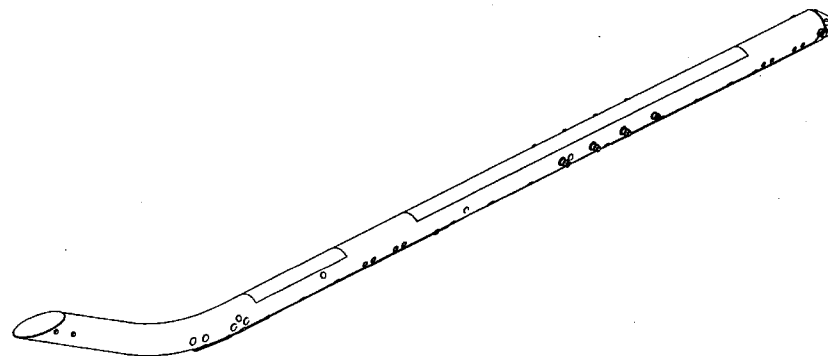
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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	AK	D2750	SHEET 1 OF 11
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	350 SKIDTUBE ASSEMBLY	NTS
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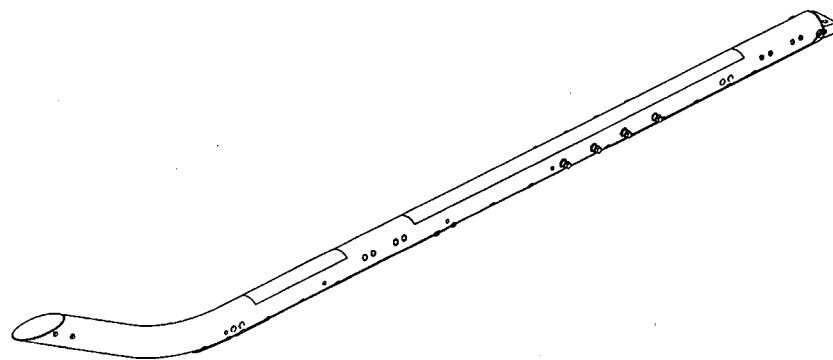


D2750-042 350 SKIDTUBE ASSEMBLY, RH

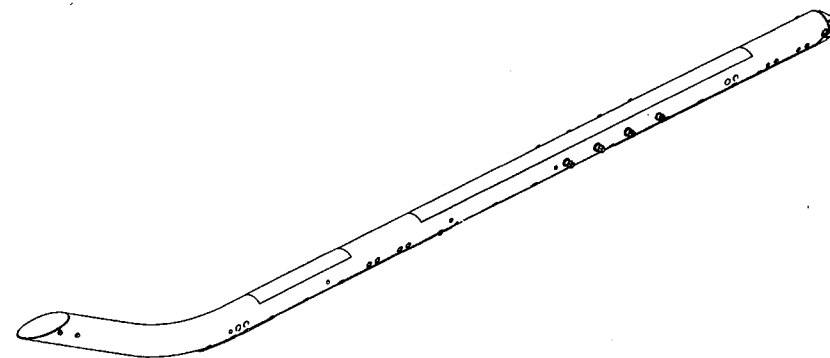
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



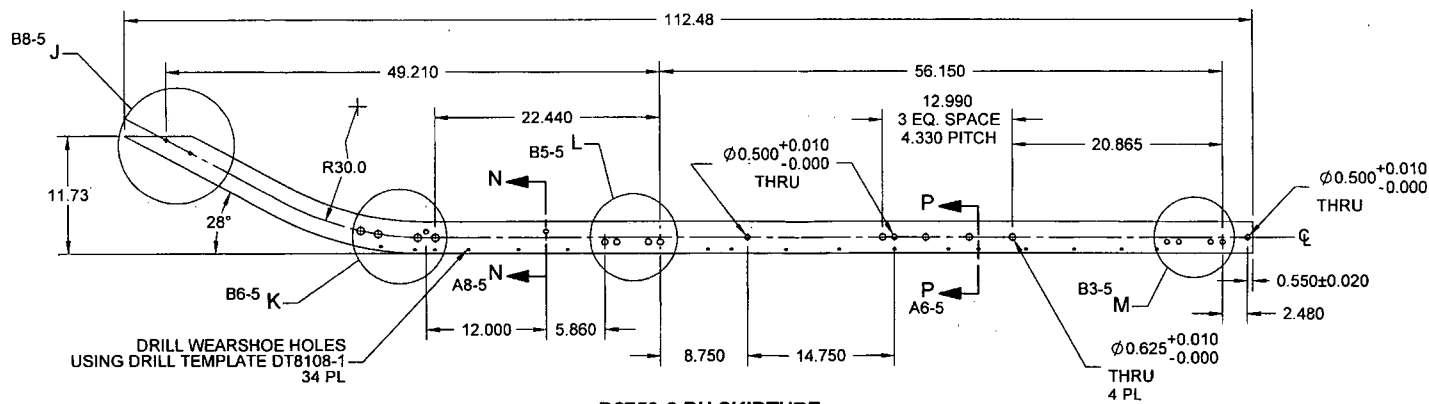
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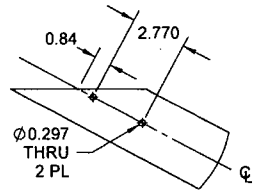
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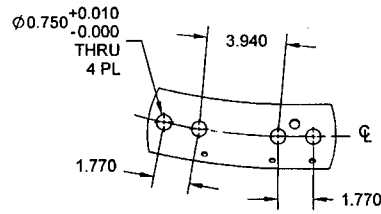
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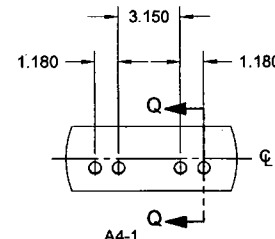
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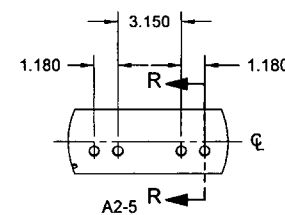
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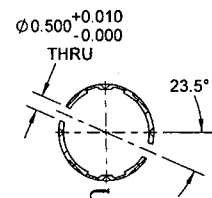
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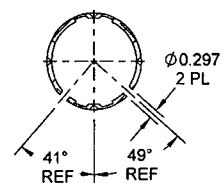
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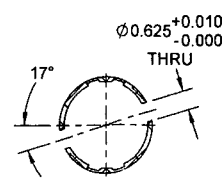
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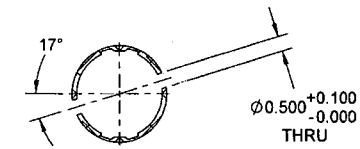
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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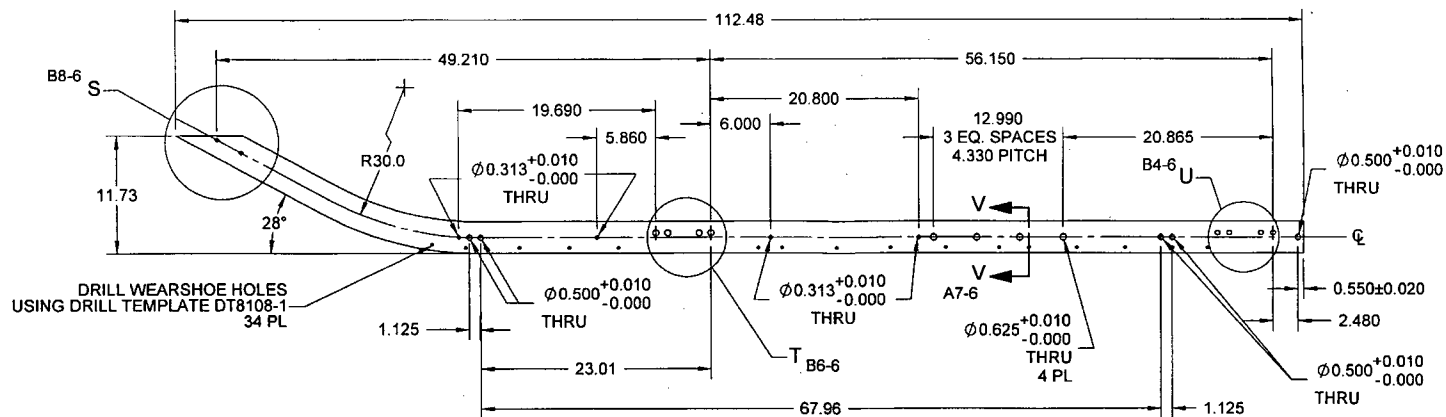
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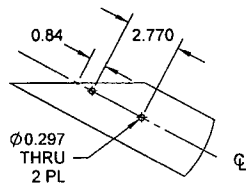
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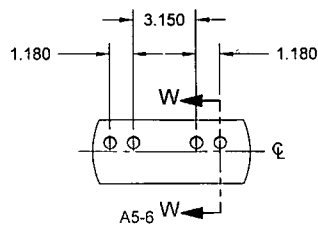
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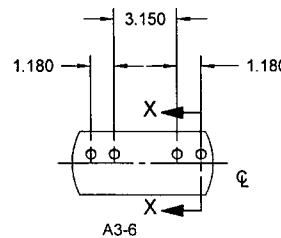
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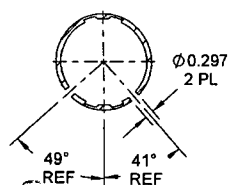
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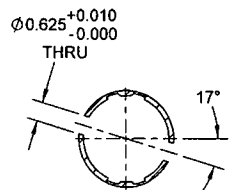
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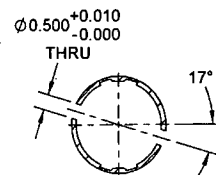
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SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



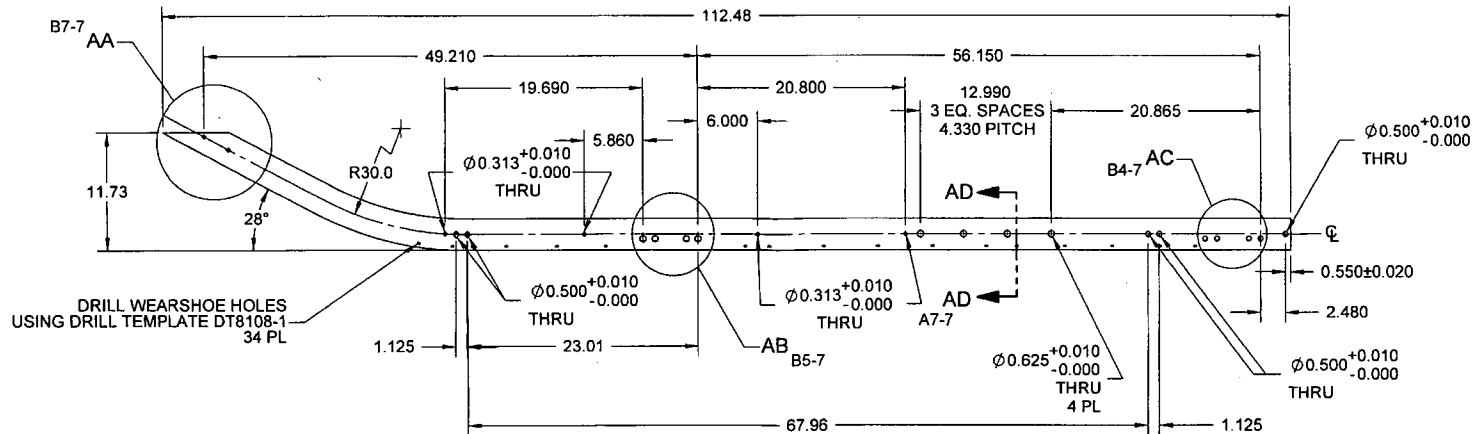
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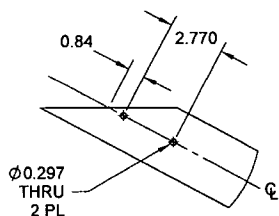
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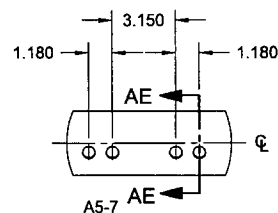
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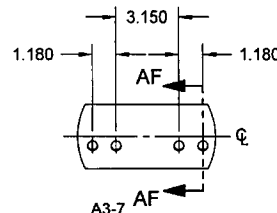
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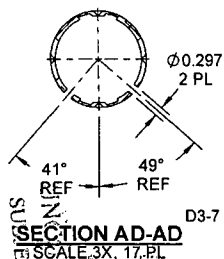
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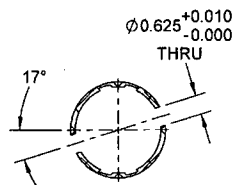
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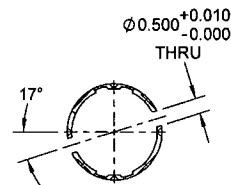
DETAIL AC
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



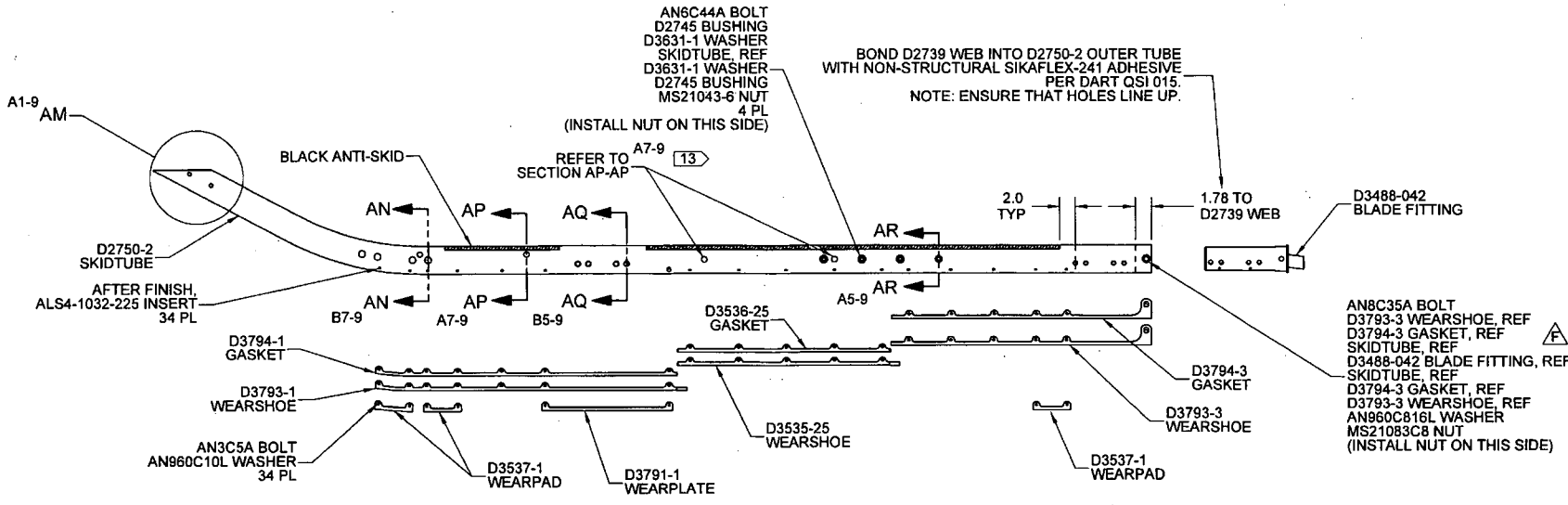
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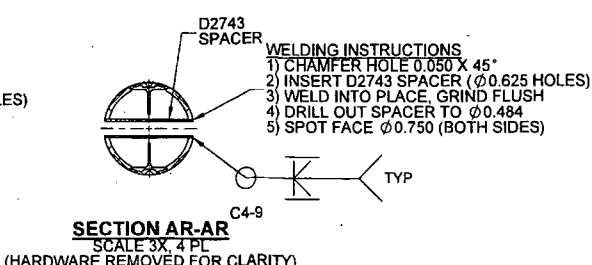
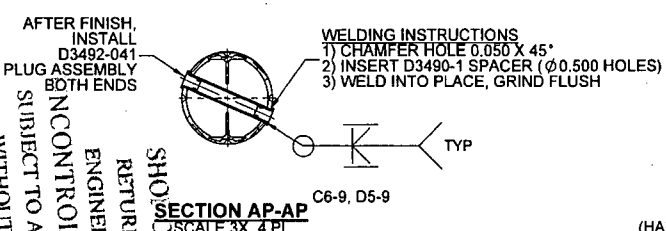
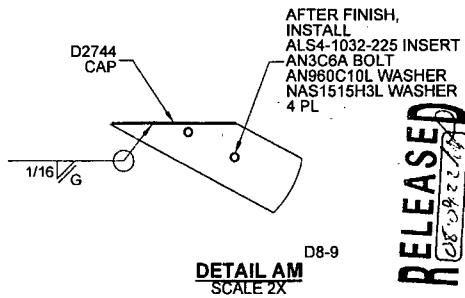
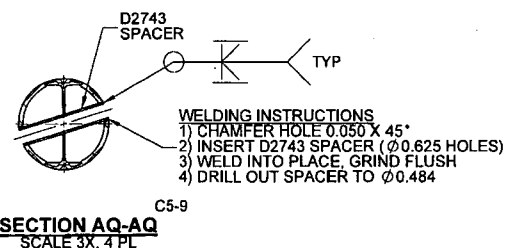
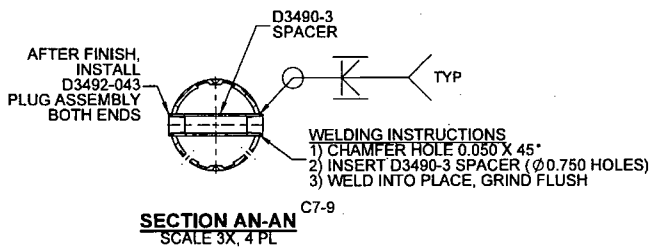
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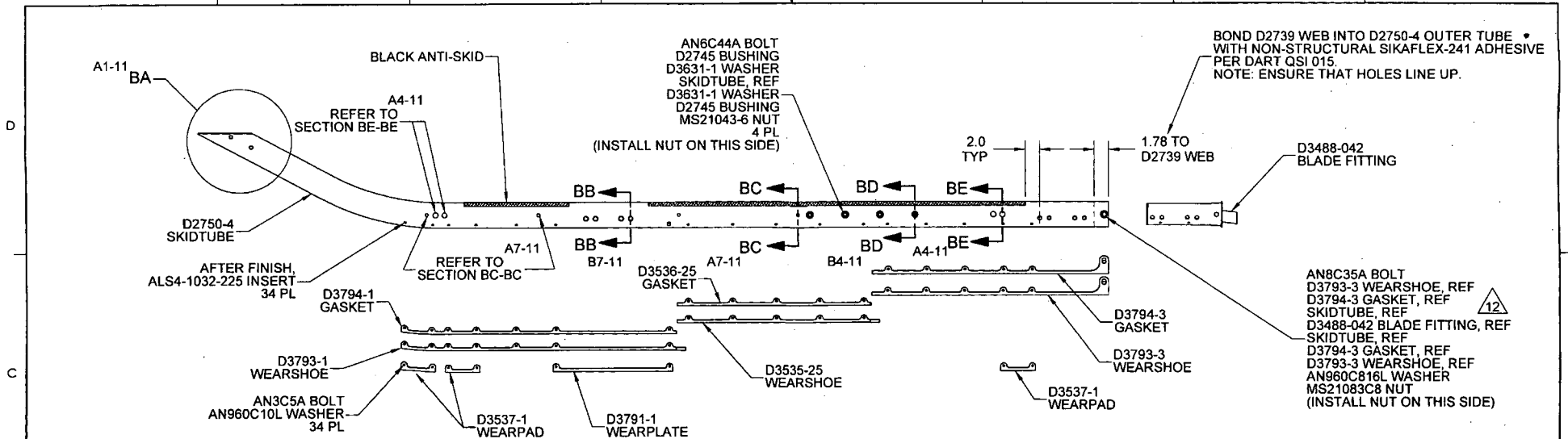


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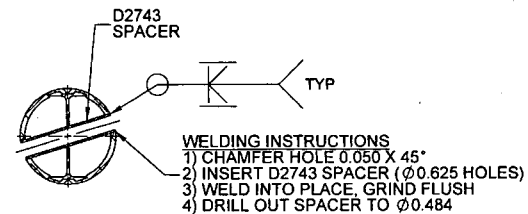
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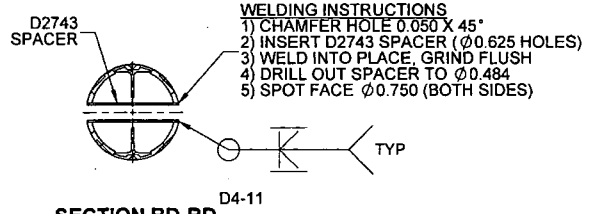
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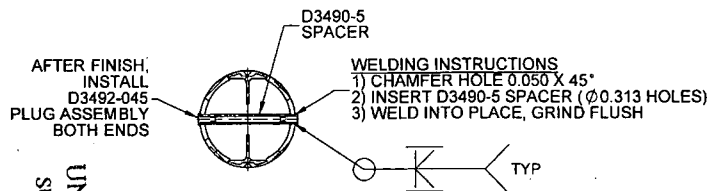
D2750-044 350 SKIDTUBE ASSEMBLY, RH



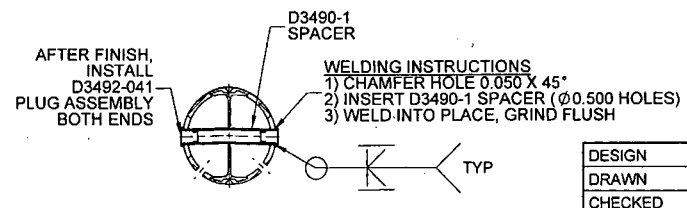
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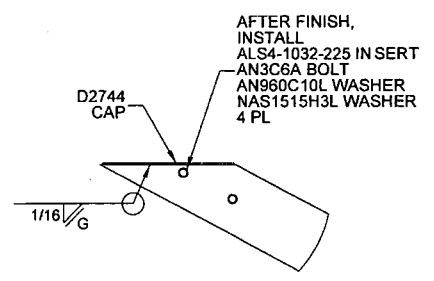
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B43125
Part number: 1350 636 011
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Louis Boyd Date of Test Coupon 08/11/03
Welder Barclay Elliot Date of Test Coupon 08/11/03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld